



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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12022

D4840-041
Job Sheet 189339



Part No: D4840-041

Job Qty: 6 pcs

Part Name: Upper Cutter Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/22/19

Job Tracking No:

Created By: Dara Macdonald

Due Date: 3/18/19

Description:

Type: ~~Stock~~ **SOLD**

Note: DWG REV A IPP REV:A 13.04.29 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	6 pcs		3/18/19	0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		DAS
							Packaging 1 - 9		36
							Packaging 1 - 10		9-88
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		
							Packaging 1 - 31		
							Packaging 1 - 32		

				Packaging 1 - 33	Plex 1/29/19 3:37 PM Dart.Hadley.Shannon
				Packaging 1 - 34	
				Packaging 1 - 35	
				Packaging 1 - 36	
120	Small Fab - 2 - B4B	6 pcs	3/18/19	0.00 7.53	Small Fab - 1 - B4B
					Small Fab - 2 - B4B
					Small Fab - 3 - B4B
					Small Fab - 4 - B4B
					Small Fab - 5 - B4B
					Small Fab - 6 - B4B
					Small Fab - 7 - B4B
130	QC 5	6 pcs	3/18/19	0.00 0.00	QC 5 - 10
					QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22
					QC 5 - 24
					QC 5 - 3
					QC 5 - 38
					QC 5 - 42
					QC 5 - 43
					QC 5 - 49
					QC 5 - 51
					QC 5 - 58
					QC 5 - 68
					QC 5 - 9
					QC 5 - 50
					QC 5 - 30
140	Packaging 3-1 - Stock - B4B	6 pcs	3/18/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B

DAS
36
9-89

DAS
40
9-89
APR 03 2019

CKOYS 54 APR 04 2019

				Packaging 3 - 32 - B4B	Plex 1/29/19 3:37 PM Dart.Hadley.Shannon
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
150 QC 21 - SA	6 pcs	3/18/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	DAG

Part Op 110 - Pick Kit

Descriptions: 120 - Small Fab - Assemble as per dwg and apply loctite 598 on all faying surfaces. A/R LOCTITE 598:

130 - QC5- Inspect part completeness to step on W/O

140 - Identify as per dwg & Stock Location: _____

150 - Identify as per dwg & Stock Location: _____

21 APR 04 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4823-1	Upper Cutter Deflector	6 Ea (1 ea)	110-Packaging 1 - Pick Kit	5147722
D4824-1	Upper Cutter Mount	6 Ea (1 ea)	110-Packaging 1 - Pick Kit	5150356
D4838-1	Upper Cutter Body, LH	6 pcs (1 ea)	110-Packaging 1 - Pick Kit	5025770
D4838-2	Upper Cutter Body, RH	6 pcs (1 ea)	110-Packaging 1 - Pick Kit	5025273
D4839-1	Blade	12 pcs (2 ea)	110-Packaging 1 - Pick Kit	5133379 & 5166365 (9X)
MS21042L08	Nut	84 Ea (14 ea)	110-Packaging 1 - Pick Kit	5134219
MS27039-08-19	Screw	84 Ea (14 ea)	110-Packaging 1 - Pick Kit	5104359
NAS1149FN832P	Washer	168 Ea (28 ea)	110-Packaging 1 - Pick Kit	5143776

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	D4823-1	6	10	0
	D4824-1	6	3	0
	D4838-1	6	11	0
	D4838-2	6	11	0
	D4839-1	12	16	0
	MS21042L08	84	1,225	0
	MS27039-08-19	84	836	0
	NAS1149FN832P	168	3,162	0

Part Specifications

Specifications could not be found.

Plex 1/29/19 3:37 PM Dart.Hadley.Shannon



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Job Sheet 189339



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Part Weight: 0 lbs

Status: New

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Note: DWG REV A IPP REV:A 13.04.29 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	3/18/19	3/18/19	0.00	0.00	Start Up Stores/Pkg-1		
110	Packaging	6 pcs	3/18/19	3/18/19	0.00	0.00	Packaging1-5		
120	Small Fab	6 pcs	3/18/19	3/18/19	0.00	7.53	Small Fab-7		
130	QC	6 pcs	3/18/19	3/18/19	0.00	0.00	QC5		
140	Packaging	6 pcs	3/18/19	3/18/19	0.00	0.00	Packaging3-2		
150	QC21-SA	6 Ea	3/18/19	3/18/19	0.00	0.00	QC21		

Part Op 120 - Assemble as per dwg and apply loctite 598 on all faying surfaces. A/R LOCTITE 598: _____
Descriptions:

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4823-1	Upper Cutter Deflector	6 Ea (1 ea)	90-Start up Operation	
D4824-1	Upper Cutter Mount	6 Ea (1 ea)	90-Start up Operation	
D4838-1	Upper Cutter Body, LH	6 pcs (1 ea)	90-Start up Operation	
D4838-2	Upper Cutter Body, RH	6 pcs (1 ea)	90-Start up Operation	
D4839-1	Blade	12 pcs (2 ea)	90-Start up Operation	5166365
MS21042L08	Nut	84 Ea (14 ea)	90-Start up Operation	5134219
MS27039-08-19	Screw	84 Ea (14 ea)	90-Start up Operation	5104359
NAS1149FN832P	Washer	168 Ea (28 ea)	90-Start up Operation	5143716

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D4823-1	6	0	0
	D4824-1	6	3	0
	D4838-1	6	11	0
	D4838-2	6	11	0
	D4839-1	12	16	0
	MS21042L08	84	1,330	0
	MS27039-08-19	84	841	0
	NAS1149FN832P	168	3,211	0

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

Part Specifications
Specifications could not be found.

Plex 1/22/19 3:22 PM Dart.Macdonald.Dara

Entered: _____ Date: _____



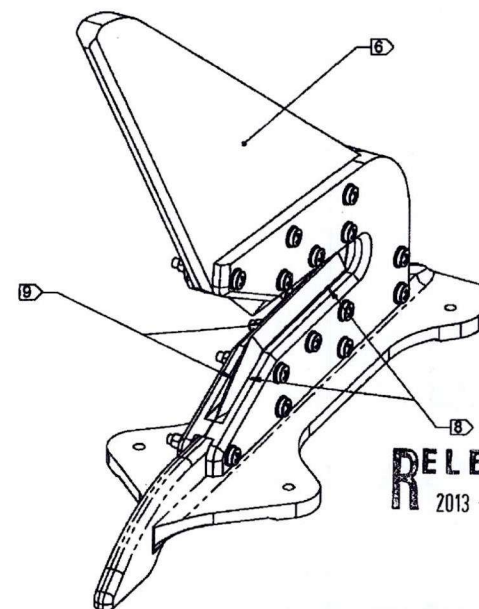
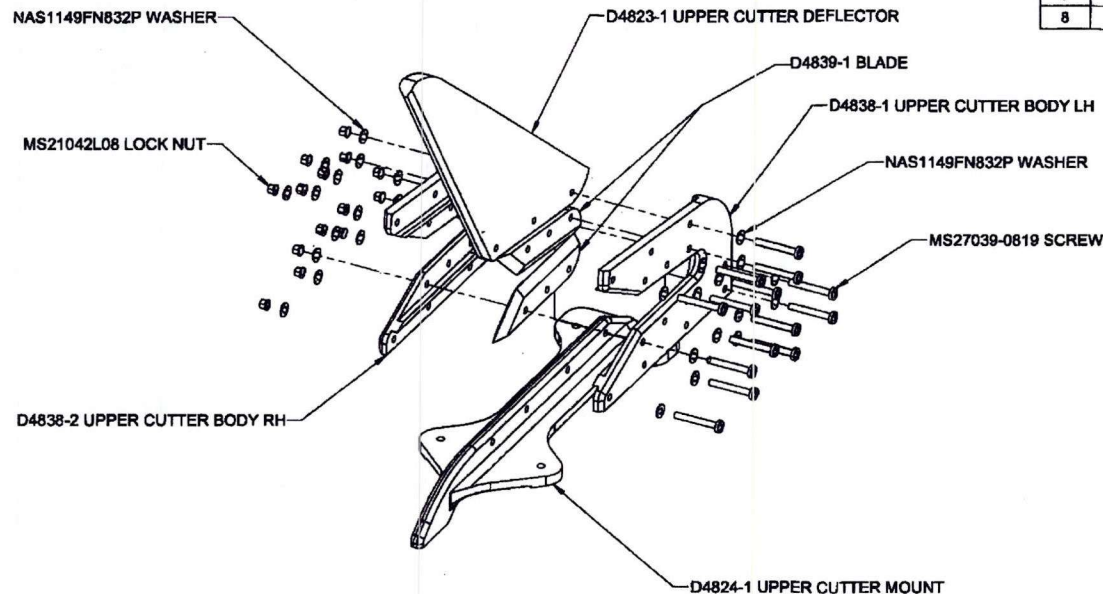
WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS			
		Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐
Date :	Sequence #:	QTY Affected :			MRB (QSI042)
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor
					QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY			
		☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled	☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread
		Other/Details:			

ITEM	QTY -041	P/N	DESCRIPTION
1	1	D4823-1	UPPER CUTTER DEFLECTOR
2	1	D4824-1	UPPER CUTTER MOUNT
3	1	D4838-1	UPPER CUTTER BODY LH
4	1	D4838-2	UPPER CUTTER BODY RH
5	2	D4839-1	BLADE
6	28	NAS1149FN832P	WASHER (AN980C10)
7	14	MS27039-0819	SCREW
8	14	MS21042L08	LOCKNUT



D4840-041 UPPER CUTTER ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4840-041", AGUSTA WESTLAND KIT NUMBER "TBD", REVISION, BATCH NUMBER AND MANUFACTURE DATE, USING AN X-TENSION STAMP, AS PER QSI 044 METHOD 6.2
- 7) WEIGHT: 3.77 LBS (1.63 KGS)
- 8) APPLY RTV SEALANT TO ALL FAYING SURFACES UPON ASSEMBLY
- 9) CUTTING EDGE INTENDED TO BE SHARP. DO NOT BREAK SHARP EDGE.

A		NEW RELEASE		DB	13.05.23
REV.	DESCRIPTION			BY	DATE
DESIGN	DB	DART AEROSPACE LTD			
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA			
CHECKED	A.P.	DRAWING NO.	D4840	REV. A	
MFG. APPR.	2/1			SHEET 1 OF 1	
APPROVED	1/2	TITLE		SCALE	
DE APPR.	1/1	UPPER CUTTER ASSY		NTS	
DATE	13.05.23				
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Cross tube ☐ Small Fab ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Ec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		
Date : _____	Container No: S168832 Part: D4840-041 Job No: 189339 Serial No/Batch: S168832 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____ Date: 04/02/19			MRB (QSI042)
Descr _____				Completed By _____
				Lead hand / Supervisor _____
				QC / QA Coordinator _____
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____		Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐		